

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021792**Date Inspected:** 27-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zha Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3009G

Weld No: 040

Welder: 050242

WPS-B-T-2233-ESAB

PCMK: SEG-3009L

Weld No: 041

Welder: 055491

WPS-B-T-2233-ESAB

PCMK: SEG-3009J

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Weld No: 031  
Welder: 055564  
WPS-B-T-2233-ESAB

PCMK: SA-3066-001  
Weld No: 003 and 006  
Welder: 044795  
WPS-B-T-2232-ESAB

PCMK: SA-3214-001  
Weld No: 007  
Welder: 044790  
WPS-B-T-2233-ESAB

PCMK: SEG-3019N  
Weld No: 284, 294, and 304  
Welder: 051356  
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Zha Hai Feng.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

PCMK: DP-3161-001  
Weld No: 035, 038, 211, 214, and 215  
WR: 20276  
Welder: 215553  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: DP-3160-001  
Weld No: 037, 039, 040, 217, and 218  
WR: 20272  
Welder: 050969  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019Z  
Weld No: 011  
WR: 19727  
Welder: 044779  
WPS-345-SMAW-2G(2F)-FCM-Repair-1

PCMK: SEG-3019E-1

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Weld No: 178  
CWR: 2650  
Welder: 054013  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: FB-3287-001  
Weld No: 018  
Welder: 067610  
WPS-B-P-2114-FCM-1

PCMK: DP-3076-001  
Weld No: 024  
Welder: 216086  
WPS-B-P-2213-TC-U4b-FCM-1

### Bay 16

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Xu Tao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: W2-SB16-003  
Tack Weld No: 132~161  
Welder: 201074  
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Xu Tao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: W2-SB27-004  
Tack Weld No: 132~161  
Welder: 216839  
WPS-B-T-2112

PCMK: W2-SB27-005  
Tack Weld No: 132~161  
Welder: 215065  
WPS-B-T-2112

### Bay 19

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This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Heat Straightening (HSR) process.

ZPMC QC is identified as Xu Tao.

Listed below are the locations that were identified by this QA inspector.

PCMK: BK-004B-001

Bottom Panel

HSR-1(B)-9501

ZPMC was observed on this date performing grinding on various welds for PCMK BK-005A-002 and BK-004A-013. It was noted that during the grinding operation ZPMC was both cleaning the welds and grinding the welds to the appropriate contour

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Rice,Brett	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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